

Work Order ID 147334

Friday, June 10, 2016 11:23:45 AM

647.3804

147334

Page 1

Item ID: 647.3804

Revision ID:

Item Name: Lower Cutter Assy High

Start Date: 6/8/2016 Start Qty: 2.00

Required Date: 6/11/2016 Req'd Qty: 2.00

Reference:

REV. N/C Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.3800	n/c								

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

DAS
6 JUN 14 2016
9:39

120 0.00

120

Small Fab

Memo

0.13

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 134524
exp. date: 09/17

2X
16/06/14
DAS
36
9:39

130 QCS- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.01

Quality Control

(2)
JUN 14 2016
DAS
38
9:39

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 147334

147334

Page 2

Friday, June 10, 2016 11:23:45 AM

Item ID: 647.3804 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Cutter Assy High
Start Date: 6/8/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/11/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location. CK027	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.03							
Quality Control									

2

0.06
6
9.50

JUN 15 2016

MLJ

JUN 16 2016

dm

16/06/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Friday, June 10, 2016 11:23:45 AM

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Work Order ID: 147334

147334

Parent Item: 647.3804

647 3804

Parent Item Name: Lower Cutter Assy High

Start Date: 6/8/2016

Required Date: 6/11/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701		Manufactured	No			110	Each	5.0000	1	2			DAG 6 9-89
646 9701									**				
Cutter Sub Assembly													

Location	Loc Qty	Loc Code
cck012	5	
142645	2	
142646	3	

NAS1149FN832P

Purchased

No

110

Each

1,875.000

6

12

NAS1149FN832P

Washer

Location	Loc Qty	Loc Code
GA	457	
M133316	16	
M133769	441	
ST260a	1200	
M134257	1200	
ST263	218	
M133709	218	

DAG
6
9-89

JUN 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 2

Friday, June 10, 2016 11:23:45 AM

Work Order ID: 147334

147334

Parent Item: 647.3804

647.3804

Parent Item Name: Lower Cutter Assy High

Start Date: 6/8/2016

Required Date: 6/11/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Purchased

No

110

Each

1,131.000

3

6

MS21042L08

Nut

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

310

m133134

3

m134063

307

ST303

737

m133922

37

m134574

200

m134654

300

m134962

200

ST308

84

m134376

84

MS27039-08-19

Purchased

No

110

Each

517.0000

3

6

MS27039-08-19

Screw

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

218

m132930

84

m133077

22

m134063

112

over006

100

m134294

100

ST277

199

m134142

199

647.3902

Manufactured

No

110

Each

2.0000

1

2

647.3902

Lower Deflector Assembly, High

DAS

6

9-89

Location

Loc Qty

Loc Code

cck052

2

145301

2

Friday, June 10, 2016 11:23:45 AM

Shop Packet Print

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JUN 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 9 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 5, 6, 7, & 8 UPON ASSEMBLY

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTECTIVE REVISION PER:		N/C
12/C	INITIAL RELEASE	09-08-09	P. BRAVO

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO 147334 NLS
160610

				1		9	647.3911	212 UPPER DEFLECTOR		
				I		8	647.3910.	412 UPPER DEFLECTOR		
A/R	A/R	A/R	A/R		7	601.2045	RTV. LOCITE 598			
I					6	647.3902	LOWER DEFLECTOR ASSY HIGH			
	I				5	647.3901	LOWER DEFLECTOR ASSY LOW			
3	3	3	3		4	601.2765	SCREW	M527039-081P		
3	3	3	3		3	601.1541	LOCKNUT	N521D4CLZP		
6	6	6	6		2	601.2764	WASHER	FMS1149FNBSZF		
I	I	I	I		1	646.9701	CUTTER SUB ASSY			
X	X	X	X			647.3804	LOWER CUTTER ASSY HIGH			
X	X	X	X			647.3803	LOWER CUTTER ASSY LOW			
X	X	X	X			647.3802	212 UPPER CUTTER ASSY			
X	X	X	X			647.3801	412 UPPER CUTTER ASSY			
.3804	.3803	.3802	.3801		FIND #	PART #	DESCRIPTION	MATL	SPEC.	
				QTY						
NEXT ASSY (\$)										
647.3700										
ORIGINAL DATE MODIFIED BY DRAWING REV. J LAC DON DESIGNED APPROVAL BY DATE UPPER CONTRACT NO:				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300						
				CUTTER ASSY USE CASE CODE DWG NO. 8 07MAZE 647.3800 FVL N/C SCALE NONE I SURF L OF C						